

Date: Tuesday, 7/4/2006 3:18:26 PM
User: Kim Johnston

Process Sheet

SLIP

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27745
Estimate Number : 11393
P.O. Number : NIA
This Issue : 7/4/2006 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NIA Type : PURCHASED PARTS
Previous Run : 27745
Written By :
Checked & Approved By :
Comment : Est. A 05.03.22 New issue KJ/JLM
Est Rev:B Per Rev C 06-07-03 JLM

Drawing Name : BUBBLE WINDOW, LH
Part Number : D32691
Drawing Number : D3269 REVC/DSI9329 B
Project Number : N/A
Drawing Revision : C/B
Material : NIA
Due Date : 7/5/2006 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1602
Manufacture D3269-1 as per Dwg D3269
Possible Supplier: Canus
Material release note is required

C207105106

(10)

2.0 D32691P Bubble Window, LH R44



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bubble Window, LH R44

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

C47/24 (7)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1


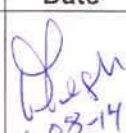
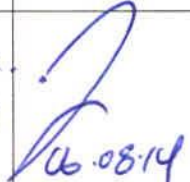

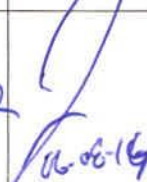
1-Engrave P/N & B/N on lower edge as per Dwg D3269

2-Wrap window in plastic wrap in a clean area.

SB 06/08/08 7

SB 06/8/21 - (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-14	4.0	Window has voids in material causing a blur in the vision path needed by the pilots.		Return to supplier (canus) and have them inspect for root cause of the voids and replace the windows, as per NCR 067	 06-08-14	 06-08-14		 06-08-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06-08-23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 7/4/2006 3:18:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE WINDOW, LH

Job Number: 27745

Part Number: D32691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓

06-08-23 (6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

M/R

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

J. Shel 06-08-23

Job Completion



06-08-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

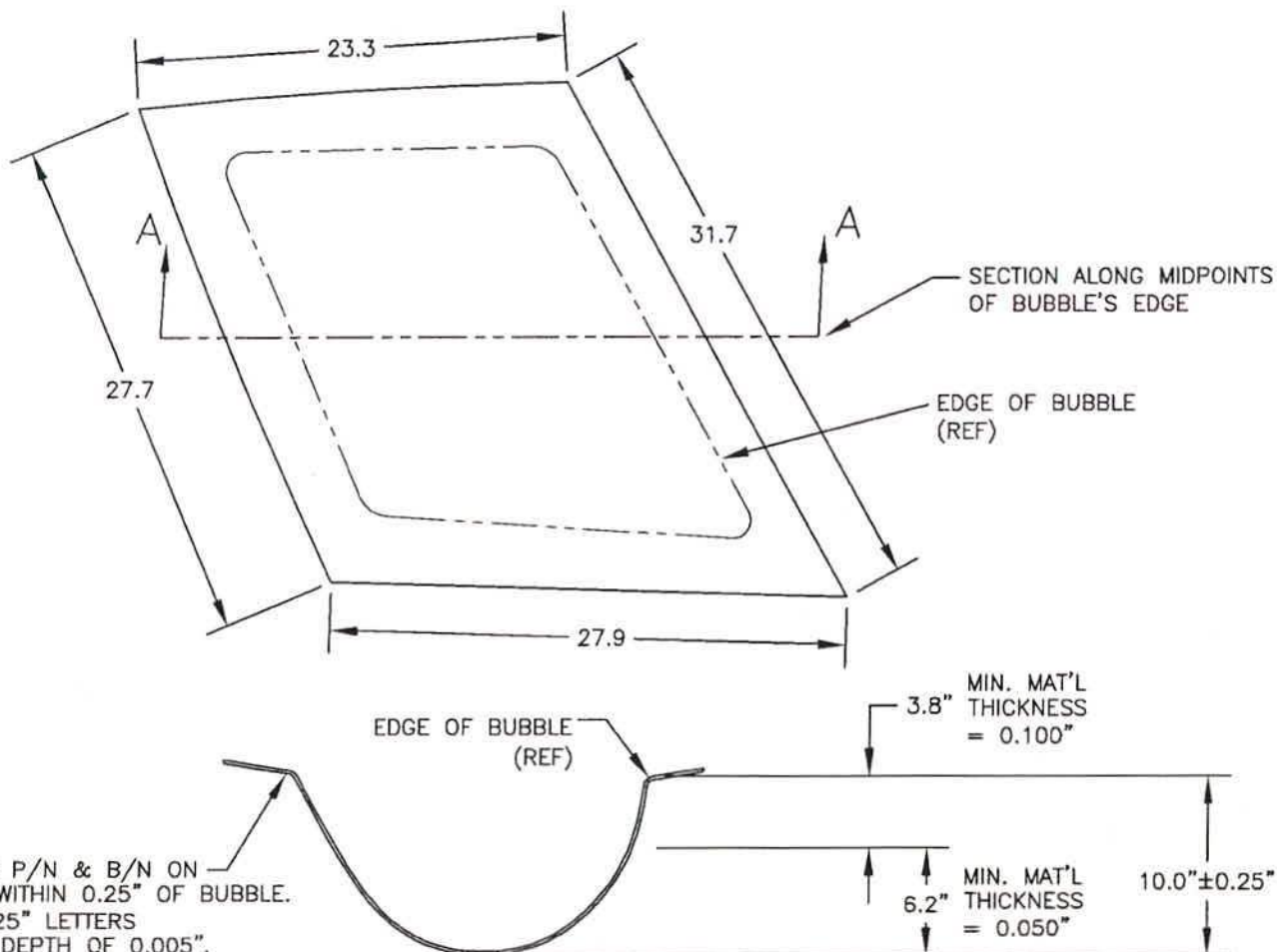
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	CP	DRAWN BY	ip	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	HA	APPROVED	HA	DRAWING NO. D3269	REV. C SHEET 1 OF 1
DATE	06.06.22	TITLE BUBBLE WINDOW (R44)			SCALE 1:10
A	05.02.18	NEW ISSUE			
B	05.03.10	UPDATE MATERIAL SPEC.			
C	06.06.22	NO LONGER TRIMMED			

RELEASED
de. de. 24SECTION A-A**D3269-1 BUBBLE WINDOW, LH (SHOWN)/ D3269-2 BUBBLE WINDOW, RH (OPPOSITE)**

- 1) FORM PER D3269-1T1B (-1) OR D3269-2T1B (-2)
FORMING PROCESS:
 - (a) DRAPE OVER D3269-1T1/-2T1 MOLD
 - (b) HEAT TO 250°F
 - (c) VACUUM FORM TO SPECIFIED HEIGHT
 - (d) LEAVE FOR AT LEAST 20 MINUTES COVERED WITH INSULATED BLANKETS TO COOL
- 2) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.188 TH. MINIMUM THICKNESS AFTER FORMING AS SHOWN ABOVE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27745

DART

DESIGN GP	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED H	DRAWING NO. DSI 9329	REV. B SHEET 1 OF 1
DATE 06.06.26	TITLE BUBBLE WINDOW INSTALL MOD.		SCALE NTS
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A
REF. CANADIAN STC: SH05-13 ISSUE 1
REF. FAA STC: SR02088NY

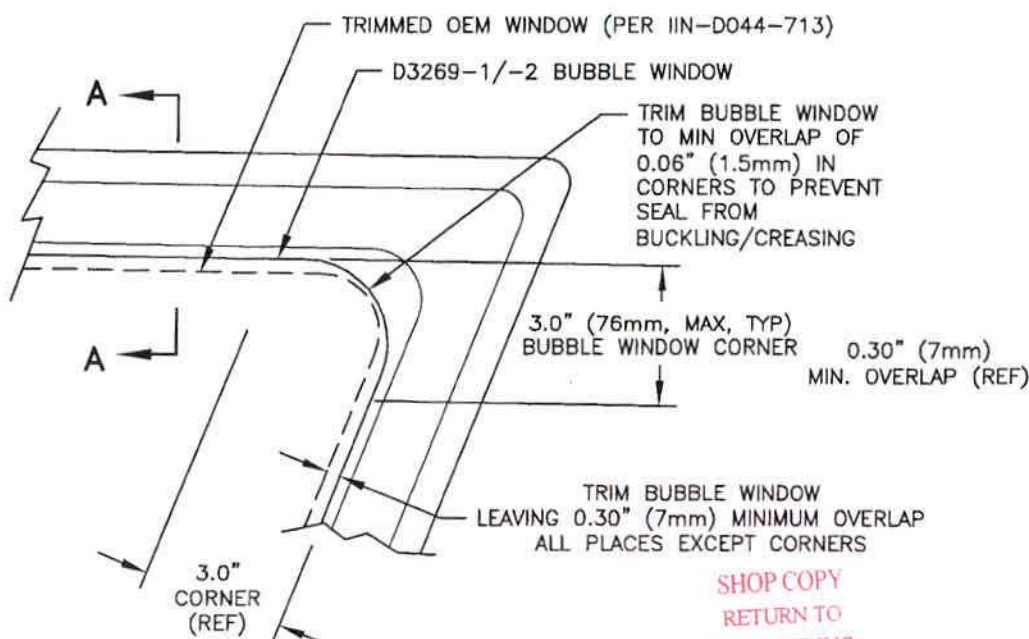
PURPOSE: For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

PROCEDURE:

- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

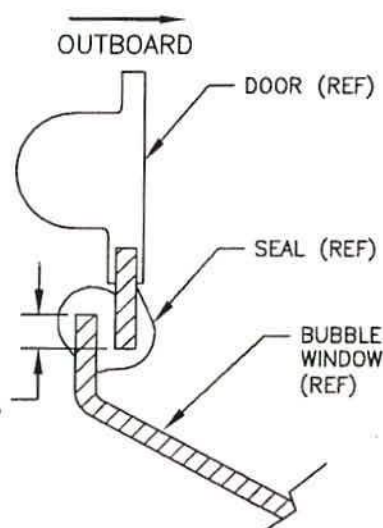
FIGURE 1

LOOKING AT INSIDE CORNER OF DOOR



SECTION A-A

(NOT TO SCALE)



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WORK ORDER
NO. 27745

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.06.26
CERT. NO.: SH05-13
ISSUE NO.: 1

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Packing Slip 127740

CUSTOMER NO. 163233

BILL TO: DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

SHIP TO: SAME

Attn: Accounts Payable

(613)632-3336

DATE
07/27/06

SHIP VIA
CANUS

F.O.B.
Our Dock

TERMS
Net 30 days

P.O. NUMBER
PO00001602

ORDER DATE
07/27/06

SALESPERSON
TM

PART NUMBER

DESCRIPTION

QUANTITY

REQ.

SHIPPED

B.O.

MFG
MFG

D3269-1 LEFT BUBBLE WINDOW
D3269-2 RIGHT BUBBLE WINDOW

7
7

7
7